

Date: Wednesday, 03/06/2009 8:03:10 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE EXTENTION
Job Number	: 48338		
Estimate Number	: 14000		
P.O. Number	:	Part Number	: D39433
This Issue	: 03/06/2009 S.O. No. :	Drawing Number	: D3943 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: A
Previous Run	:	Material	:
Written By	: <u>JLM/09-06-03</u>	Due Date	: 10/06/2009 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 09-06-03 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B0500X03000	1010-1025 BAR.500"x3.00"
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MAT NOT PULLED



Comment: Qty.: 1.2684 f(s)/Unit Total: 1.2684 f(s)
 1010-1025 BAR.500"x3.00"
 BATCH: 108386 IB 9-6-3

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3943
 Dwg Rev: A
 Prog Rev: A

IB 9-6-3

①

2-Deburr if necessary IB 9-6-3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



IB 9-6-3

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

mk 09/06/03

①

5.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

1-MILL DIMPLE USING 1/2" BALL mk 09/06/03

2-DRILL .300" DIA HOLE USING "N" DRILL N/A

3-MILL .375" STUD N/A

mk 09-06-03

①

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE EXTENTION

Job Number: 48338

Part Number: D39433

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-06-04

①

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

10:30

OVEN TEMPERATURE:

320

FINISH TIME:

11:00

09-06-04

①

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-06-04

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Dan St.

09-06-04

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/05

Job Completion



09-06-04

ITEM No.	QTY -041	QTY -051	QTY -053	PART NUMBER	DESCRIPTION	PREFERED SUPPLIER
1	X			D3943-041	GROUND HANDLING CRANK ASSEMBLY	
5	1	X		D3943-051	HANDLE ASSEMBLY	
6	1		X	D3943-053	CHAIN ASSEMBLY	
11		1		D3943-1	HANDLE	M/F HANDLE FROM DIS-ASSEMBLED ITEM 39
12	1			D3943-3	HANDLE EXTENSION	
13		1		D3943-5	PLATE	
14		2		D3943-7	STUD	
15			1	D3943-9	CHAIN	USE CHAIN SUPPLIED WITH ITEM 39
21	1			D2690-4	LANYARD	
22	1			D3585-1	SET SCREW	
23	1			D3949-041	REMOVE BEFORE FLIGHT FLAG	
24			1	D3954-5	CHAIN LUG	
25	1			D3954-7	RATCHET LUG	
26			1	D3954-9	GWT CHAIN PIN	
31	1			AN4-10A	BOLT	
32	1			AN960-416	WASHER	
33	1			MS21042-4	NUT	
39	1			8143919	LEVER CHAIN HOIST (POWER FIST)	PRINCESS AUTO / 4000 lbs CAPACITY
41	1			S-1475	SPRING	REID SUPPLY
42	1			3408A59	BALL PLUNGER	McMASTER CARR
43	3			HX-15	SOCKET HEAD CAP SCREW 1/4-20 UNC X 0.75 LG	HASKINS

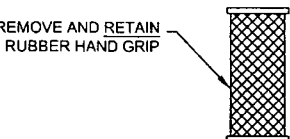
48338

RELEASED
09/05/13

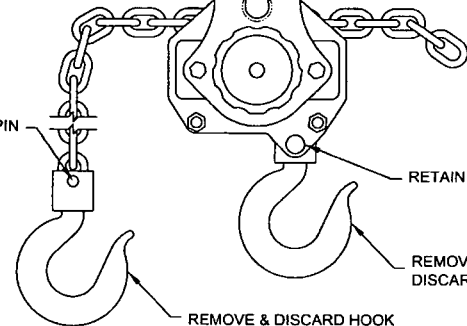
A	NEW ISSUE	AJS	09.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DSTOW / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. A
CHECKED		D3943	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		GROSS WEIGHT TOW CRANK ASSY	NTS
DE APPR.	N/A	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.05.13		

8 7 6 5 4 3 2 1

REMOVE AND RETAIN
RUBBER HAND GRIP



DISCARD PIN



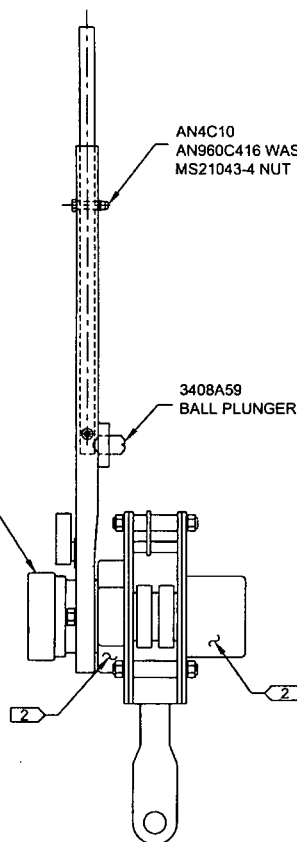
RETAIN PIN

REMOVE &
DISCARD HOOK

REMOVE & DISCARD HOOK

8143919 LEVER CHAIN HOIST
(SHOWN PRIOR TO MODIFICATION)
(CHAIN SHOWN SHORTENED FOR CLARITY)

8143919
LEVER CHAIN HOIST



AN4C10
AN960C416 WASHER
MS21043-4 NUT

3408A59
BALL PLUNGER

(CHAIN NOT SHOWN FOR CLARITY)

RE-INSTALL
RUBBER HAND-GRIP
HERE

D3943-3
HANDLE EXTENSION

D2690-4 LANYARD

D3949-041 FLAG

HX-15 S/H CAP SCREW

HX-15 S/H CAP SCREW
S-1475 SPRING

D3585-1 SET SCREW

RE-INSTALL PIN

D3943-7 RATCHET LUG

D3943-053 CHAIN ASSY

(CHAIN SHOWN SHORTENED FOR CLARITY)





D3943-041 GROUND HANDLING CRANK ASSEMBLY

RELEASED
09/05/13

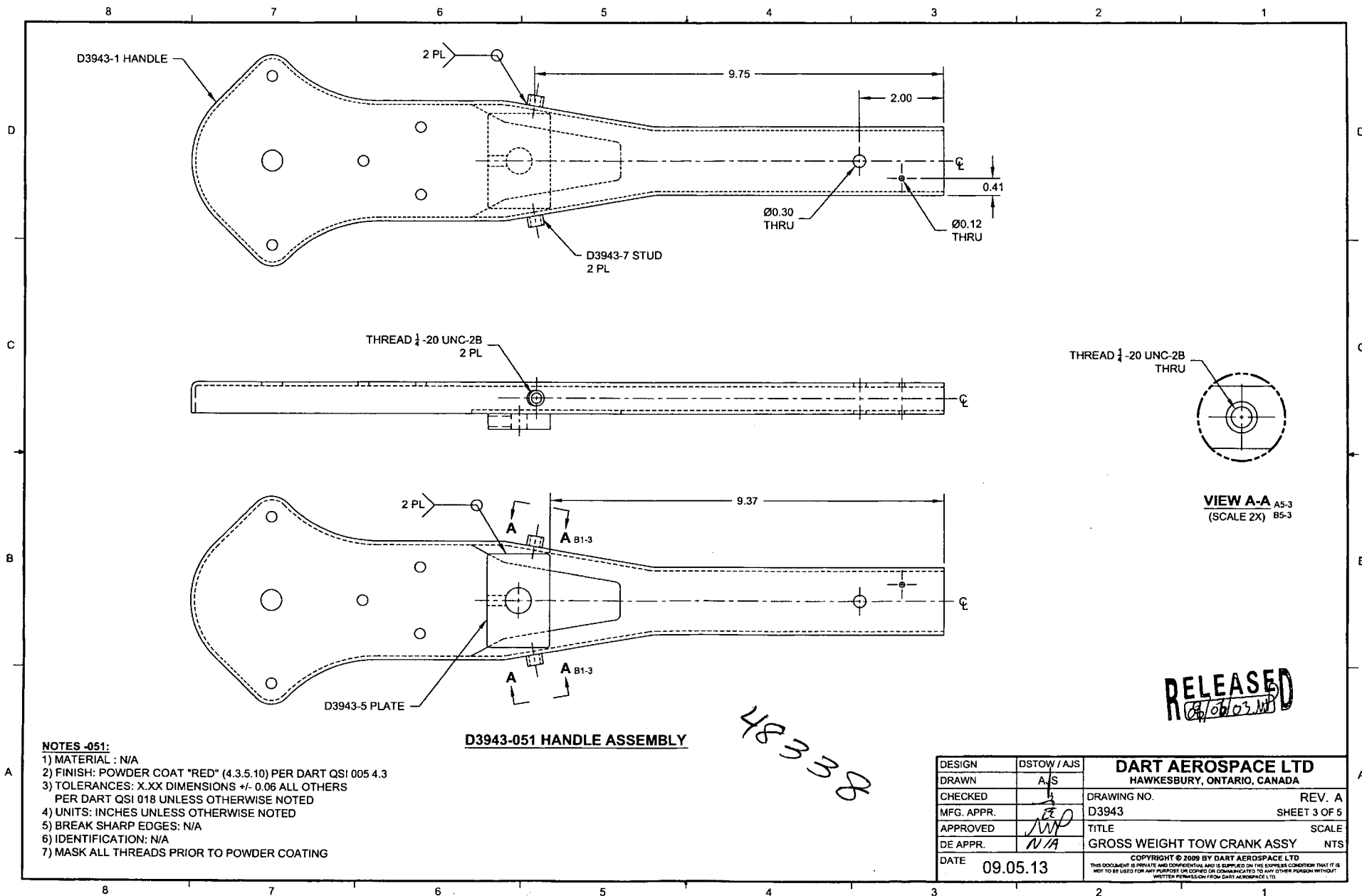
NOTES -041:

- 1) MATERIAL: N/A
- 2) FINISH: DISASSEMBLE LEVER CHAIN HOIST (ITEM 39) AND POWDER COAT "RED" (4.3.5.10) PER DART QSI 005 4.3 PARTS INDICATED
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3943-041" USING FINE POINT PERMANENT INK MARKER

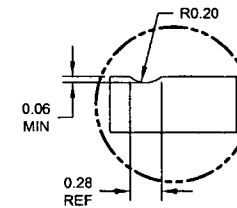
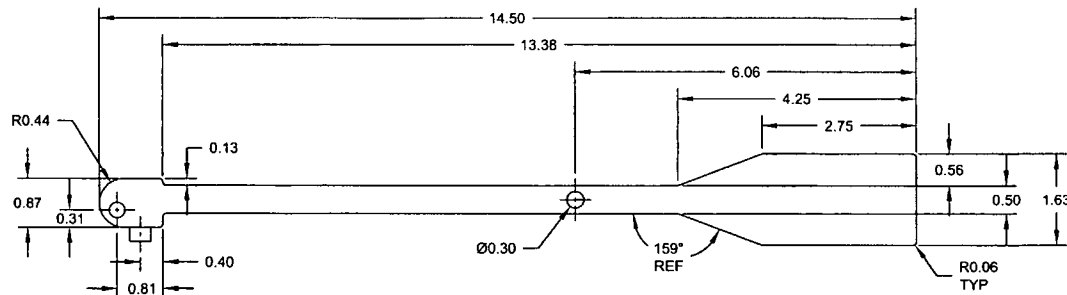
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3943	SHEET 2 OF 5
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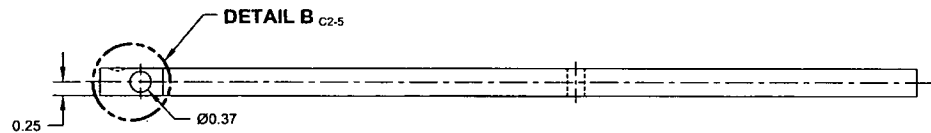
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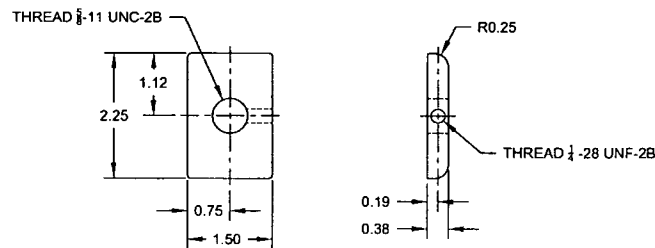
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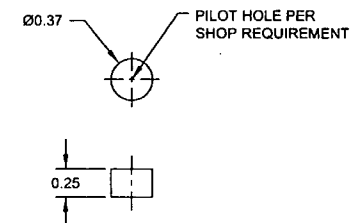
DETAIL B-B C7-5
(DIMPLE DETAIL)
(SCALE 2X)



D3943-3 HANDLE EXTENSION



D3943-5 PLATE



D3943-7 STUD
(SCALE 2X)

NOTES -11/-13:

1) MATERIAL -3 & -5: MILD STEEL, SHEET
AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-S

OR : MILD STEEL, BAR
AISI 1010-1025 OR ASTM A36/A366/A569/A570
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-B

-7: MILD STEEL, ROUND BAR
AISI 1018-1025
PER MIL-S-7097
REF DART SPEC M1018-R

- 2) FINISH -3: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3 PARTS INDICATED
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A

48338

RELEASED
9/16/07

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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8 7 6 5 4 3 2 1